

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023289**Date Inspected:** 25-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Trial Assembly / OBG segment 13CE

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG 13CE welds as per ZPMC notification # 08931.

The weld designations reviewed are as follows:

LD3030-001-068, 069, 072, 073, 081, 082, 088, 101, 102, 105~108, 114, 115, 134, 135, 138~141, 147, 148, 167, 168, 171~174, 180, 181, 200, 201, 204~207, 213, 214, 233, 234, 237, 238, 241, 242, 261, 262, 265~268, 289, 290, 293~296, 317, 318, 321~324

Trial Assembly / OBG segment 13AW – 13BW

This QA Inspector observed the following work in progress:

ZPMC personnel performing fit up and tack welding of OBG 13AW and 13BW Bottom Panel weld. Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

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## WELDING INSPECTION REPORT

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Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4g position of Bottom Panel Base Metal Repair, as per B-CWR # 2861. The welder is identified as 067829. Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-345-4G(4F)-FCM-Repair-1.

### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey (+86) 15000026784 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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